

Work Order ID 51327

August 19, 2009 10:49:13 AM



Page 1

Item ID: D2917-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Saddle LH

Start Date: 08/19/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 08/24/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: *MF*

Date: *09-08-19*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2917

Rev B

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Program batch number ☐ Machine Step No 1 as per Folio FA436 and visually inspect as per Dwg D2917 & attached Dimension Sheet ☐ Machine Step No 2 as per Folio FA436 and visually inspect as per Dwg D2917 & attached Dimension Sheet ☐ Machine Step No 3 as per Folio

ank 09/09/08

09/09/08

4

0

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per Dwg D2917 & attached dimension sheet

ank 09/09/08

4

0

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

ank 09/09/08

4

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	=> 809/09/09						
170 Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							
180 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

809/9/9 (4)

09/09/09

MF 09-09-09

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Picklist Print

Page 1

August 19, 2009 10:49:13 AM

Work Order ID: 51327



Parent Item: D2917-1RevB



Parent Item Name: Saddle LH

Start Date: 08/19/2009

Required Date: 08/24/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6102-010RevD		Manufactured	No			100	Each	0.0000	4.0000			

Saddle Billet

Batch #: 51423

amt 09/09/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART AEROSPACE LTD	Work Order: 51327
Description: Saddle LH	Part Number: D2917-1
Inspection Dwg: D2917 Rev. A1	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2917 Rev. A1 and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.175	0.205		.194	.196	.190	.190		
B	0.090	0.110		.090	.094	.094	.090		
C	0.250	0.270		.266	.263	.263	.261		
D	1.599	1.619		1.618	1.610	1.610	1.610		
E	0.180	0.220		.186	.186	.180	.180		
F	0.277	0.297		.280	.280	.281	.281		
G	1.385	1.400		1.388	1.392	1.390	1.390		
H	3.170	3.230		3.195	3.198	3.200	3.200		
I	0.175	0.217		.186	.180	.177	.179		
J	0.470	0.530		.500	.500	.500	.500		
K	1.498	1.508		1.504	1.502	1.503	1.506		
L	4.436	4.446		4.442	4.436	4.436	4.442		
M	0.257	0.262	DT8683	.259	.260	.260	.260		
N	1.225	1.235		1.234	1.224	1.226	1.230		
O	1.103	1.113		1.104	1.106	1.109	1.107		
P	0.470	0.530		.502	.500	.500	.500		
Q	0.438	0.443	DT8682	.442	.441	.441	.441		
R	0.490	0.510		.502	.507	.506	.505		
S	1.745	1.755		1.750	1.750	1.750	1.744		
T	7.990	8.010		8.003	8.004	8.004	8.004		
U	3.495	3.505		3.498	3.500	3.500	3.494		
V	0.175	0.205		.205	.205	.205	.205		
W	1.990	2.010		2.002	2.003	2.002	2.002		
X	0.760	0.765		.760	.760	.760	.760		
Y	0.307	0.312		.312	.312	.311	.311		
Z	0.615	0.635		.627	.630	.628	.628		
AA	0.177	0.197		.188	.188	.188	.188		
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>[Signature]</i>
Date: 09/09/08

Audited by: <i>[Signature]</i>
Date: 09/09/08

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	04.09.20	Added DT8683 & DT8682	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

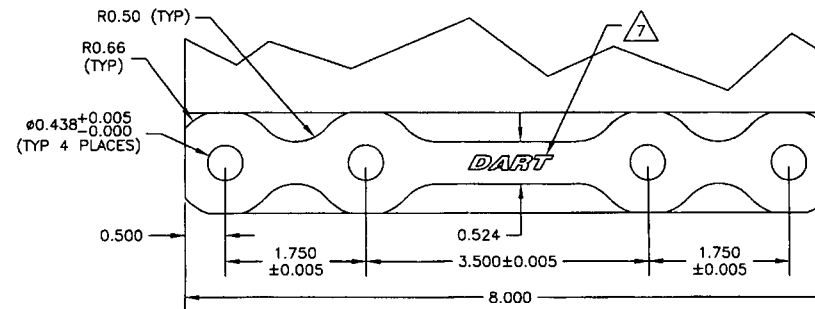
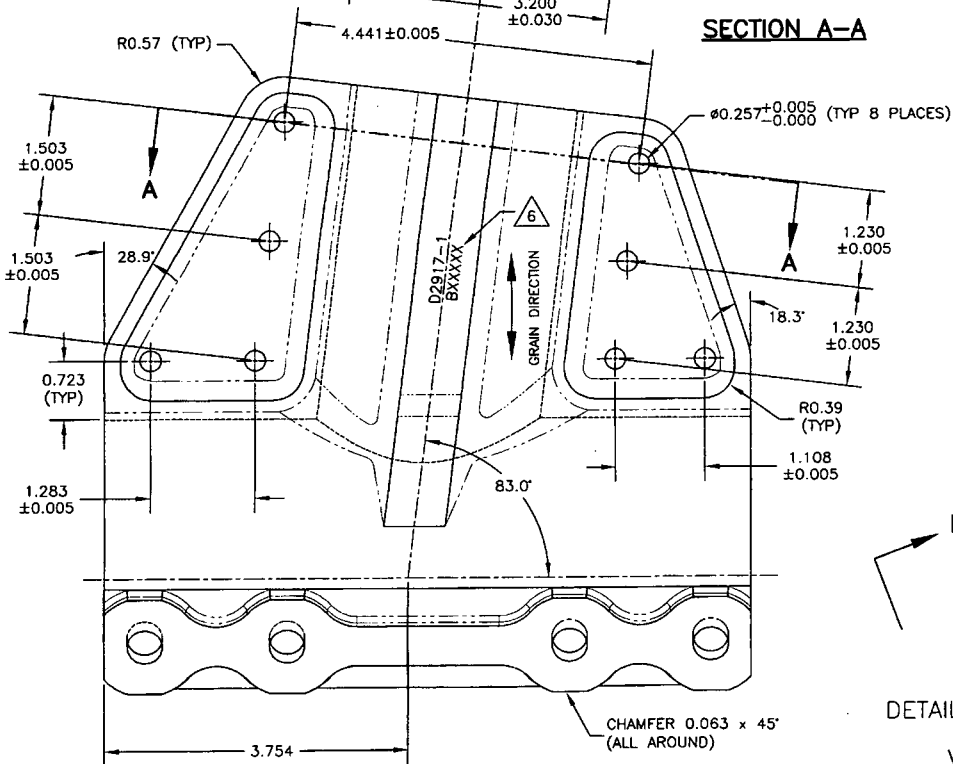
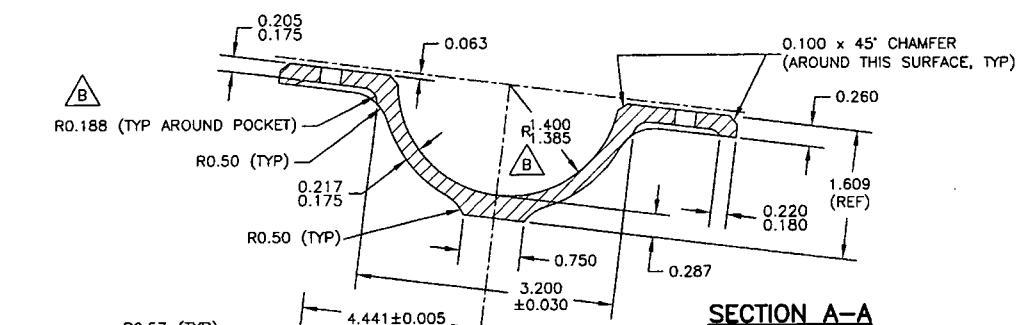
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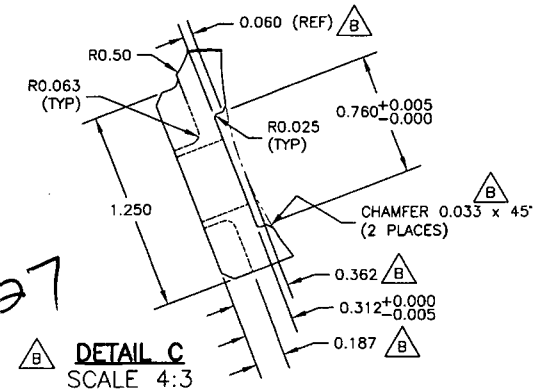
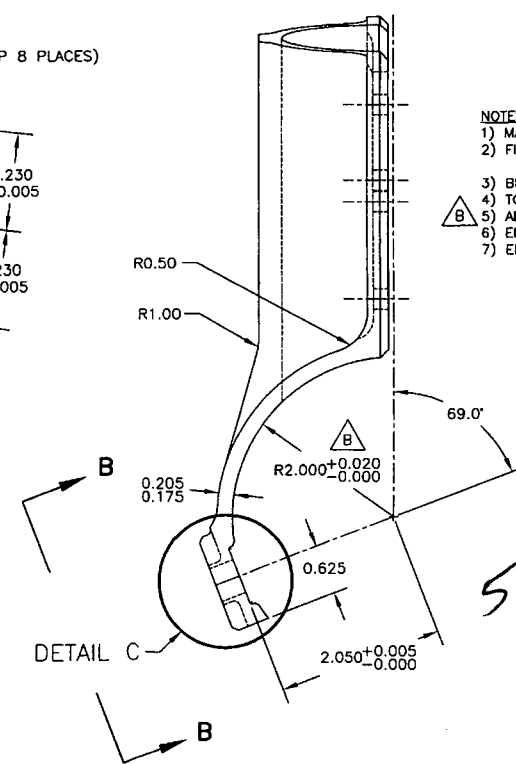
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VIEW B-B

D2917-1 LH SADDLE (SHOWN)
D2917-2 RH SADDLE (OPPOSITE)

- NOTES:
- 1) MATERIAL: ALUMINUM 6061-T6/T651 PER QQ-A-250/11
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
 - 7) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125



B	07.06.26	ADD 0.362, 0.187, 0.060, CHAMFER; ADD DETAIL C; R0.188 WAS R0.30; ADD TOL TO R2.000; ADD NOTES
A	04.05.31	NEW ISSUE
DESIGN	9P	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	07.06.26	TITLE SADDLE
DRAWING NO.	D2917	REV. B
SHEET 1 OF 1		SCALE 2:3

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DART AEROSPACE LTD.

RELEASED
c7.07.31

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